

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009874**Date Inspected:** 25-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 1

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Counter Weight. Inspection Notification number- 004475. The weld designations reviewed are as follows:

(CW001-PP080-131,132,133)

(CW001A-PP080-001)

(CW001-PP062-131,132,133)

(CW001A-PP062-001)

(CW001-PP074-131,132,133)

(CW001A-PP074-001)

OBG # SEGMENT 6CW (OPEN YARD)

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for

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this date. The member is identified as longitudinal diaphragm. Inspection Notification number - 004478. The weld designations reviewed are as follows:

(SEG 031D-018)

(SEG 031F-018)

OBG # BAY 9

This QA inspector performed Ultrasonic Test of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Ultrasonic Test report for this date. The member is identified as Deck Panel U Rib. Inspection Notification number - 004471. The weld designations reviewed are as follows:

(DP3043-001-160,161,170,171,180,181)

(DP3041-001-135,136,145,146)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 2

Flux Cored Arc Welding Process:

Welding of weld joint –088,056 located on PCMK FB3054-001. Welder is identified as 045203. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4b-F.

Welding of weld joint –022,023 located on PCMK FB3054-001. Welder is identified as 062438. ZPMC QC is identified as Zhan hai feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 5

Flux Cored Arc Welding Process:

Welding of weld joint –011 located on PCMK 10TR2-019. Welder is identified as 217185. ZPMC QC is identified as Zhong chong biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –011 located on PCMK 10TR3-034. Welder is identified as 250353. ZPMC QC is identified as Zhong chong biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Welding of weld joint –011 located on PCMK 10TR3-015. Welder is identified as 068858. ZPMC QC is identified as Zhong chong biao. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No Relevant Conversation

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Sukanthan,Dhanasingh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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